

Date: Friday, 13/06/2008 1:48:40 PM
User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	DOOR ASSEMBLY
Job Number :	39871		
Estimate Number :	11403		
P.O. Number :		Part Number :	D3296041
This Issue :	13/06/2008	Drawing Number :	D3296 REV A
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	11	Drawing Revision :	A
Previous Run :	37037	Material :	
	Type :	Due Date :	23/06/2008
	SMALL /MED FAB	Qty:	12 Um: Each
Written By :			
Checked & Approved By :	JLD 08.06.13		
Comment :	Est. C 05.10.14 Added step 14 KJ/EC		
	Est Rev:D Revised Steps 06-11-20 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D32961	Door Panel
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Door Panel

Pick:

Qty	Part Number	Description	Batch
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1	D3296-1	Door Panel	B39874
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FF 08-06-23 (12)

2.0	D32963	Door Panel
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Door Panel

Pick:

Qty	Part Number	Description	Batch
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1	D3296-3 Door Panel		B39875
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FF 08-06-23 (12)

3.0	D31617	Hinge 14.0"
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Hinge 14"

Batch: B39891

FF 08-06-23 (12)

4.0	D31619	Hinge 17.0"
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Hinge 17"

Batch: B36082

FF 06-08-23 12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 13/06/2008 1:48:40 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 39871

Part Number: D3296041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

MS20470AD44

Rivet, Universal Head



Comment: Qty.: 25.0000 Each(s)/Unit Total: 300.0000 Each(s)

Rivet, Universal Head

Batch: M107823

FF 08-06-23 12

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Fabricate & assemble as per Dwg D3296.

FF 08-06-24 (12)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/06/25 (x12)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3, 5.7) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

12:00
320°
12:00

2 RACK
1:00
320°
1:00
R/L BR 08-07-01

(12)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

S 08/07/02 (x12)

10.0

D2137

Decal - No Step



Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)

Decal - No Step

Pick:

Qty Part Number Description Batch
1 D2137 Decal 39139

JS 08/07/02 (x12)

11.0

D2419

Handle



Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)

Handle

Pick:

Qty Part Number Description Batch
1 D2419 Handle 37609 x9 B39881 x3

JS 08/07/02 (x12)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 13/06/2008 1:48:40 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 39871

Part Number: D3296041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D2462

Seal



Comment: Qty.: 0.3333 f(s)/Unit Total : 3.9996 f(s)

Qty Part Number Description Batch

1 D2462 Seal

CUT ONE PIECE 4.00" LONG

37747

JS 05/07/02 (X12)

13.0

D2462

Seal



Comment: Qty.: 0.4420 f(s)/Unit Total : 5.3040 f(s)

Qty Part Number Description Batch

1 D2462 Seal

CUT ONE PIECE 5.30" LONG

37747

JS 08/07/02 (X12)

14.0

D2462

Seal



Comment: Qty.: 2.0420 f(s)/Unit Total : 24.5040 f(s)

Qty Part Number Description Batch

1 D2462 Seal

CUT ONE PIECE 24.50" LONG

37747

JS 08/07/02 (X12)

15.0

D27281

Dart Logo Label - small



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Dart Logo label small

Pick:

Qty Part Number Description Batch

1 D2728-1 Decal

39012

JS 08/07/02 (X12)

16.0

AN960JD6

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Washer

Pick:

Qty Part Number Description Batch

1 AN960JD6 Washer

6085

JS 05/07/02 (X12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 39871

Part Number: D3296041

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

MS20470AD46

Rivet, Universal Head



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Rivet, Universal Head

Pick:

Qty Part Number Description Batch

1 MS20470AD4-6 Rivet

M107082

AS 08/07/02 (12)

18.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3296

EB 08/07/03 (12)

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SO 08/07/03 (12)

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST217

AS 08/07/03 (12)

21.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/08

Job Completion



W 08/07/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

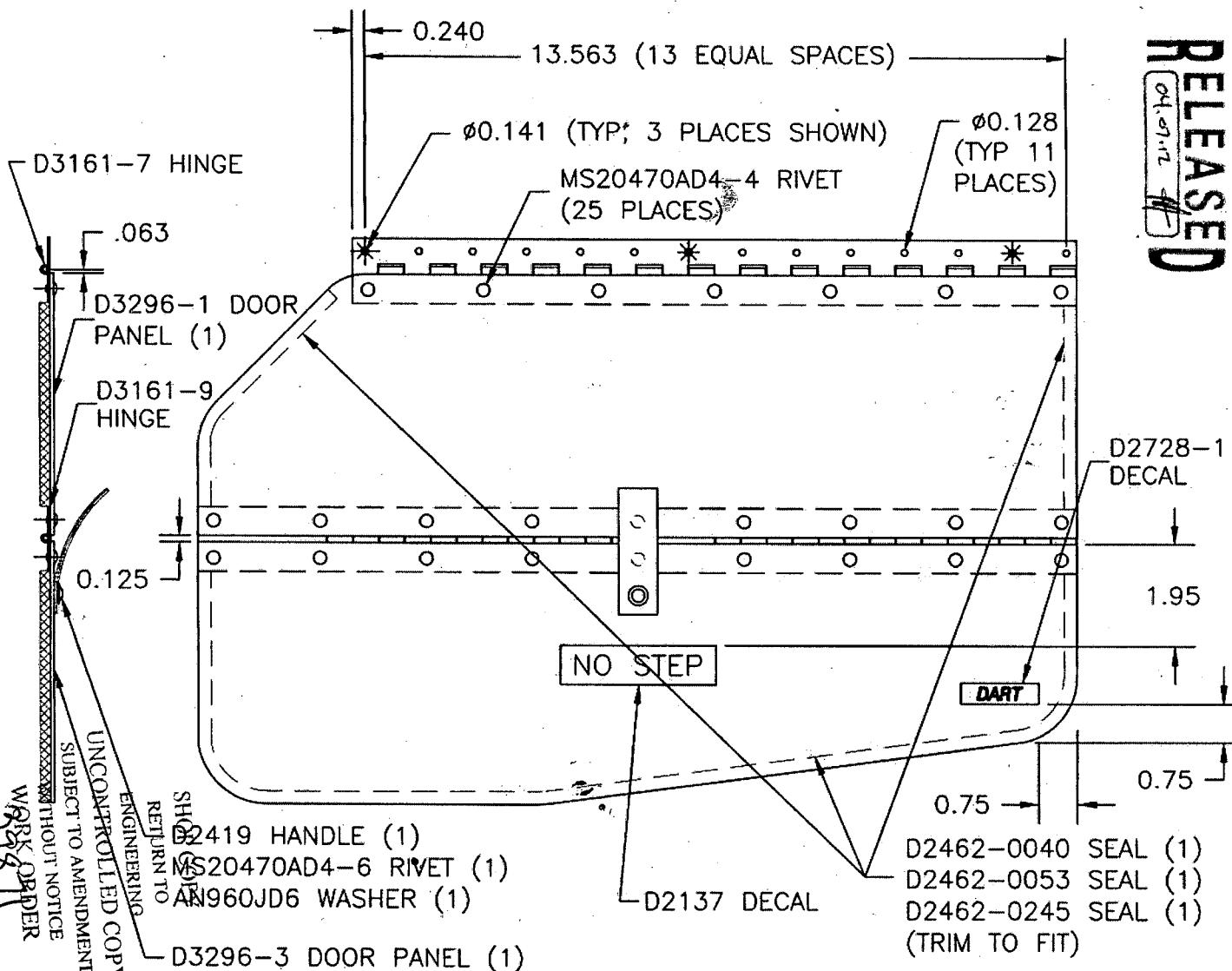
NOTE: Date & initial all entries

DART



RELEASED
04.07.12

DESIGN	IP	DRAWN BY	IP	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA
CHECKED	[Signature]	APPROVED	[Signature]	DRAWING NO. D3296
DATE	04.06.28	TITLE	DOOR ASSEMBLY	REV. A 1 OF 2
A	04.06.28	NEW ISSUE		SCALE 1:3



D3296-041 DOOR ASSEMBLY

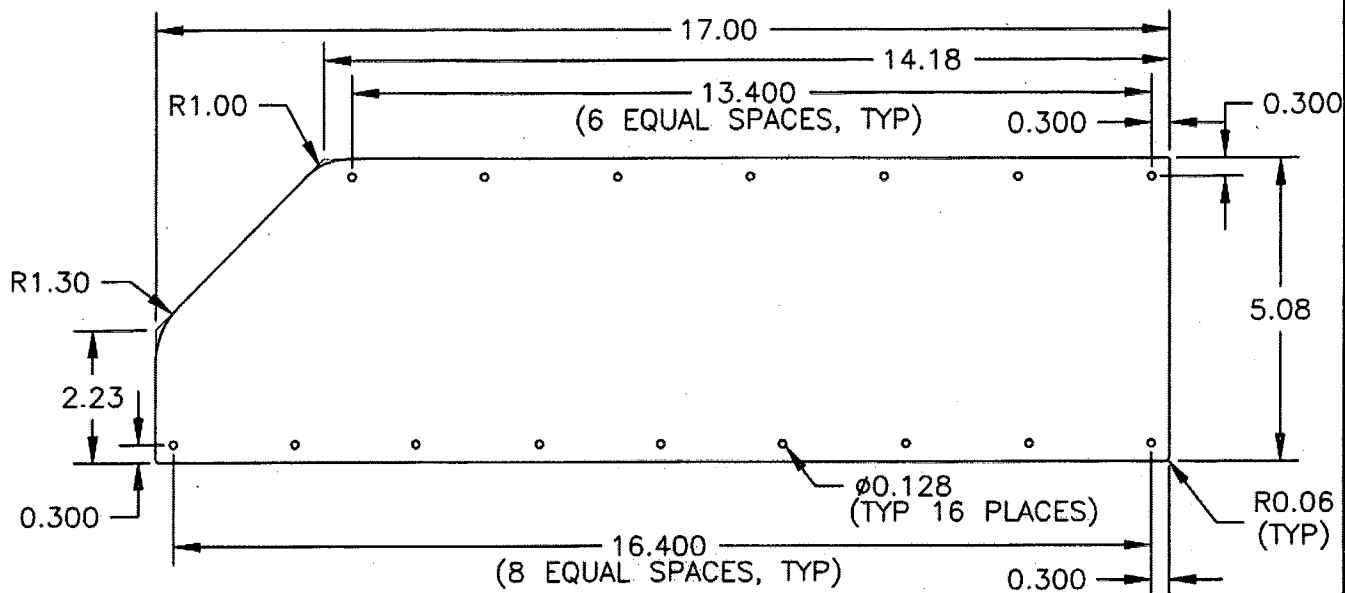
- 1) FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) INSTALL D2137 & D2728-1 DECALS, D2419 HANDLE, AND D2462 SEALS AFTER POWDER COAT
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 358

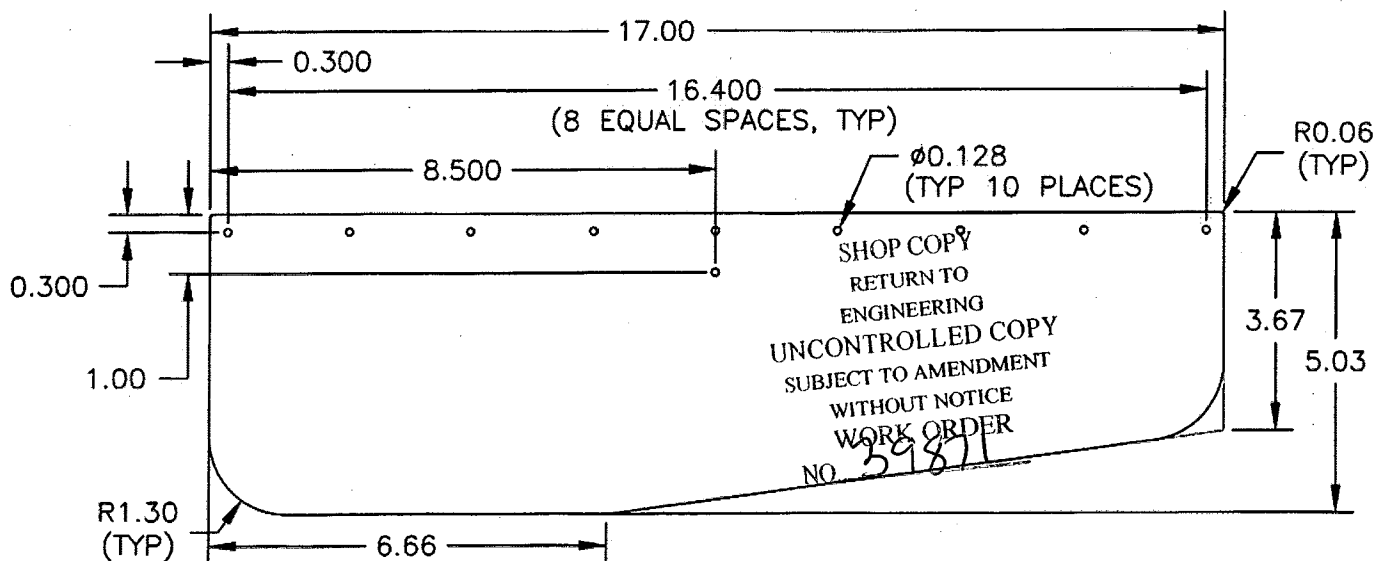
1.95
8.50
1.50



DESIGN <i>UP</i>	DRAWN BY <i>UP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3296	REV. A 2 OF 2
DATE 04.06.28		TITLE DOOR ASSEMBLY	SCALE 1:3



D3296-1 DOOR PANEL



D3296-3 DOOR PANEL

D3296-1 AND D3296-3

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK
(REF DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
04.07.12

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